- 1 We claim:
- 2 1. An apparatus for reducing the width of a plurality of slots or other openings
- 3 spaced circumferentially around a slotted tubular member comprising:
- 4 (a) a seaming roller positioned to contact the outer surface of the slotted tubular member for
- 5 transverse movement relative to the longitudinal axis of the slotted tubular member, and adapted
- 6 to apply a force onto the slotted tubular member so as to reduce the slot width;
- 7 (b) a first detector adjacent the seaming roller for detecting an initial width of
- 8 of the plurality of slots and generating a detection signal proportional to the detected initial
- 9 width;
- 10 (c) a comparator connected to the first detector for comparing the detected initial width to
- a set value indicative of a desired end slot width and to generating a correction signal
- 12 proportional to the difference;
- 13 (d) an adjustor connected to the seaming roller and the comparator, for adjusting the force
- applied by the seaming roller to the plurality of slots in response to the correction signal.
- 15 2. The apparatus of claim 1, further comprising longitudinally feeding and axially
- rotating the slotted tubular member through the seaming roller.
- 17 3. The apparatus of claim 2, wherein the adjustor includes a hydraulic cylinder to apply the
- 18 force to the seaming roller.
- 19 4. The apparatus of claim 2, wherein the adjustor includes a pneumatic cylinder to apply the
- 20 force to the seaming roller.
- 21 5. The apparatus of claim 3, wherein the slotted tubular member is formed with a plurality
- of longitudinal slots and wherein the force applied by the seaming roller as the seaming
- 23 roller moves across each of the plurality of slots is maintained with an accumulator attached to
- 24 the hydraulic cylinder.
- 25 6. The apparatus of claim 5, further comprising a plurality of seaming rollers located
- circumferentially around the slotted tubular member.
- 7. The apparatus of claim 6, further comprising clamps adjacent to the seaming roller for
- clamping the slotted tubular member so as to hold the slotted tubular member centered relative to
- 29 its longitudinal axis as it moves through the seaming roller.

- 1 8. The apparatus of claim 7, wherein the clamps includes diametrically opposed
- 2 clamping rollers to clamp the tubular member, one of said clamping rollers being adapted to hold
- a fixed position and the other being adapted to apply a dampening clamping force to compensate
- for off centre movement of the slotted tubular member.
- 5 9. The apparatus of claim 5, which further comprises a second detector adapted to detect
- 6 the final width of the plurality of slots, to generate a final width signal proportional to the
- detected final width; and wherein the comparator is adapted to compare the detected final width
- 8 signal to a set value indicative of the desired end slot width.
- 9 10. The apparatus of claim 8, which further comprises a second detector adapted to detect
- the final width of the plurality of slots, to generate a final width signal proportional to the
- detected final width; and wherein the comparator is adapted to compare the detected final width
- signal to a set value indicative of the desired end slot width.
- 13 11. The apparatus of claim 8, wherein the clamping roller adapted to hold a fixed position, is
- connected to a tempsonic controlled hydraulic cylinder in order to apply a force to hold the fixed
- 15 position.
- 16 12. The apparatus of claim 10, wherein the clamping roller adapted to hold a fixed position,
- is connected to a tempsonic controlled hydraulic cylinder in order to apply a force to hold the
- 18 fixed position.
- 19 13. The apparatus of claim 11, wherein the clamping roller adapted to apply a dampening
- clamping force, is connected to a hydraulic cylinder and an accumulator in order to apply a
- 21 dampened force.
- 22 14. The apparatus of claim 12, wherein the clamping roller adapted to apply a dampening
- clamping force, is connected to a hydraulic cylinder and an accumulator in order to apply a
- 24 dampened force.
- 25 15. The apparatus of claim 14, wherein the clamping rollers are located transverse the
- longitudinal axis of the slotted tubular member.
- 27 16. The apparatus of claim 15, wherein the first or second detector uses optics to detect the
- width of the plurality of slots.
- 29 17. The apparatus of claim 16, wherein optics comprises a camera wherein the camera is

- positioned to measure the slot width in pixels so as to generate a pixilated signal proportional to
- the width of the slot.
- 3 18. The apparatus of claim 15, wherein the first or second detector comprises a laser and a
- laser detector, the laser being positioned to direct a laser beam at the plurality of slots, and the
- laser detector being positioned to receive a reflected laser beam off the slotted tubular member
- 6 and to generate a signal proportional to the reflected laser beam.
- 7 19. The apparatus of claim 18, wherein longitudinally feeding and axially rotating the slotted
- 8 tubular member includes:
- 9 (a) a headstock housing;
- 10 (b) a chuck mounted on the headstock housing for receiving and securing the slotted tubular
- 11 member;
- 12 (c) a quill carried by the headstock housing for rotating the slotted tubular member once it is
- secured by the chuck; and
- 14 (d) a conveyor for conveying the headstock housing longitudinally relative to the seaming
- 15 roller.
- 16 20. The apparatus of claim 19, wherein the headstock housing is mounted on a track for
- longitudinal movement relative to the seaming roller.
- 18 21. The apparatus of claim 20, wherein the comparator is a programmable logic controller
- that compares received signals with inputted stored set values.
- 20 22. The apparatus of claim 21, wherein the programmable logic controller receives inputted
- 21 rates of longitudinal and axial movement for the slotted tubular member and provides output
- 22 signals to directly control the conveyor, chuck and quill.
- 23. The apparatus of claim 1 further comprising moving the seaming roller and the clamps
- longitudinally along the slotted tubular member; and axially rotating the slotted tubular member
- 25 through the seaming roller.
- 26 24. The apparatus of claim 1, wherein the slotted tubular member is metal.
- 27 25. The apparatus of claim 23, wherein the slotted tubular member is metal.
- 28 26. A method of reducing the width of a plurality of longitudinal slots or other openings
- 29 spaced circumferentially around a slotted tubular member, comprising:

providing at least one seaming roller positioned to contact the outer surface of the slotted 1 (a)

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- tubular member for transverse movement across the plurality of slots; 2
- detecting an initial width of each of the plurality of slots to generate a detection signal 3 (b)
- proportional to the detected initial dimensions; 4
- comparing the detected initial width of the slots to a set value indicative of a desired end 5 (c)
- slot width to generate a correction signal proportional to the difference; 6
- applying a downward force onto the slotted tubular member with the at least one seaming 7 (d)
- roller; and 8
- varying the force applied by the at least one seaming roller to the plurality of slots along 9 (e)
- the slotted tubular member in response to the correction signal. 10
- The method of claim 26, further comprising longitudinally feeding and axially rotating 27. 11
- the slotted tubular member through the at least one seaming roller. 12
- The method of claim 27, further comprising maintaining the force applied by the at least 13 28.
- one seaming roller as the seaming roller moves across each of the plurality of slots with an 14
- 15 accumulator.
- The method of claim 28, further comprising clamping the slotted tubular member so as to 16 29...
- hold the slotted tubular member centered and to dampen harmonic vibrations as the slotted 17
- tubular member moves through the seaming roller. 18
- The method of claim 29, further comprising detecting the final width of each of the 30. 19
- plurality of slots, generating a final width signal proportional to the detected final width, and 20
- comparing the final width signal to the set value indicative of the desired end slot width. 21
- The method of claim 30, further comprising moving the at least one seaming roller 31. 22
- longitudinally along the length of the slotted tubular member. 23
- The method of claim 26, further comprising moving the at least one seaming roller 32. 24
- longitudinally along the length of the slotted tubular member. 25
- A method of reducing the width of a plurality of longitudinal slots or other openings 26 33.
- spaced circumferentially around a slotted tubular member, comprising: 27
- providing at least one seaming roller positioned to contact the outer surface of the slotted 28 (a)
- tubular member for transverse movement across the plurality of slots; 29

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- 1 (b) applying a downward force onto the slotted tubular member with the at least one seaming
- 2 roller; and
- 3 (c) maintaining the force applied by the at least one seaming roller as the seaming roller
- 4 moves across each of the plurality of slots with an accumulator.

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- 5 34. A method of reducing the width of a plurality of longitudinal slots or other openings
- 6 spaced circumferentially around a slotted tubular member, comprising:
- 7 (a) providing at least one seaming roller positioned to contact the outer surface of the slotted
- 8 tubular member for transverse movement across the plurality of slots;
- 9 (b) applying a downward force onto the slotted tubular member with the at least one seaming
- 10 roller; and
- (c) longitudinally feeding and axially rotating the slotted tubular member through the at least
- 12 one seaming roller.
- 13 35. A method of forming a slotted tubular member having a plurality of longitudinal slots
- 14 comprising:
- 15 (a) providing at least one seaming roller positioned to contact the outer surface of the
- slotted tubular member for transverse movement across the plurality of slots;
- 17 (b) detecting a width of each of the plurality of slots to generate a detection signal
- proportional to the detected width;
- 19 (c) comparing the detected width of the slots to a set value indicative of a desired end slot
- width to generate a correction-signal proportional to the difference;
- 21 (d) applying a downward force onto the slotted tubular member with the at least one
- 22 seaming roller; and
- 23 (e) varying the force applied by the at least one seaming roller to the plurality of slots along
- 24 the slotted tubular member in response to the correction signal so that each opening has a profile
- with a width tolerance, that throughout the length of the slot profile, varies no more than +/-
- 26 0.0381 mm from the desired end slot width.
- 27 36. The method of claim 35, further comprising detecting the final width of each of the
- 28 plurality of slots, generating a final width signal proportional to the detected final width, and
- comparing the final width signal to the set value indicative of the desired end slot width.

- 1 37. The method of claim 36, further comprising varying the force applied by the at least one
- 2 seaming roller to the plurality of slots along the slotted tubular member in response to a final
- 3 correction signal proportional to the difference between the final width signal and the set value
- 4 indicative of the desired end slot width.
- 5 38. An apparatus for reducing the width of a plurality of longitudinal slots or other openings
- 6 spaced circumferentially around a slotted tubular member comprising:
- 7 (a) a seaming roller positioned to contact the outer surface of the slotted tubular member for
- 8 transverse movement across the plurality of slots, and adapted to apply a force onto the slotted
- 9 tubular member so as to reduce the slot width;
- 10 (b) first detector adjacent the seaming roller for detecting a width of the plurality of slots
- and generating a detection signal proportional to the detected width;
- 12 (c) a comparator connected to the first detector for comparing the detected width to
- a set value indicative of a desired end slot width and to generating a correction signal
- proportional to the difference;
- 15 (d) an adjustor connected to the seaming roller and the comparator, for adjusting the force
- applied by the seaming roller to the plurality of slots in response to the correction signal.
- 17 39. A method of reducing the width of a plurality of longitudinal slots or other openings
- spaced circumferentially around a slotted tubular member, comprising:
- 19 (a) providing at least one seaming roller positioned to contact the outer surface of the slotted
- 20 tubular member for transverse movement across the plurality of slots;
- 21 (b) detecting a width of each of the plurality of slots to generate a detection signal
- 22 proportional to the detected width;
- 23 (c) comparing the detected width of the slots to a set value indicative of a desired end slot
- width to generate a correction signal proportional to the difference;
- 25 (d) applying a downward force onto the slotted tubular member with the at least one seaming
- 26 roller; and
- 27 (e) varying the force applied by the at least one seaming roller to the plurality of slots along
- 28 the slotted tubular member in response to the correction signal.
- 29 40. A method of forming a slotted tubular member having a plurality of longitudinal slots

- 1 comprising:
- 2 (a) providing at least one seaming roller positioned to contact the outer surface of the
- 3 slotted tubular member for transverse movement across the plurality of slots;
- 4 (b) detecting a width of each of the plurality of slots to generate a detection signal
- 5 proportional to the detected width;
- 6 (c) comparing the detected width of the slots to a set value indicative of a desired end slot
- 7 width to generate a correction signal proportional to the difference;
- 8 (d) applying a downward force onto the slotted tubular member with the at least one seaming
- 9 roller; and
- 10 (e) varying the force applied by the at least one seaming roller to the plurality of slots along
- the slotted tubular member in response to the correction signal so that each opening has a profile
- with a width tolerance, that throughout the length of the slot profile, varies no more than +/-
- 13 0.0127 mm from the desired end slot width.
- 14 41. A method of forming a slotted tubular member having a plurality of longitudinal slots
- 15 comprising:
- 16 (a) providing at least one seaming roller positioned to contact the outer surface of the
- slotted tubular member for transverse movement across the plurality of slots;
- 18 (b) detecting a width of each of the plurality of slots to generate a detection signal
- proportional to the detected width;
- 20 (c) comparing the detected width of the slots to a set value indicative of a desired end slot
- 21 width to generate a correction signal proportional to the difference;
- 22 (d) applying a downward force onto the slotted tubular member with the at least one
- 23 seaming roller; and
- 24 (e) varying the force applied by the at least one seaming roller to the plurality of slots along
- 25 the slotted tubular member in response to the correction signal so that each opening has a profile
- 26 with a width tolerance, that throughout the length of the slot profile, varies no more than +/-
- 27 0.00762 mm from the desired end slot width.
- 28 42. A slotted tubular liner comprising:
- a metal slotted tubular member formed with a plurality of longitudinal slots ≤3.175mm in

- width spaced circumferentially around the member, each slot having been cut and then
- 2 transversely seamed to have a profile with a width tolerance, that throughout the length of the
- 3 slot profile, varies no more than +/-0.0127 mm from a desired end slot width.
- 4 43. The metal slotted tubular member of claim 42, wherein each slot is transversely seamed
- to have a profile with a width tolerance, that throughout the length of the slot profile, varies no
- 6 more than +/-0.00762 mm from a desired end slot width.